



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.7822
Job Sheet 169390



Part No: 647.7822

Job Qty: 20 ea

Part Name: Eye Bolt Fitting RH



Part Weight: 0 lbs

Job Created: 12/8/17

Due Date: 1/12/18

Type: Stock

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Mario Poulin

Description:

Note: DWG REV A IPP Rev A RQ 14.08.27 verified by DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea	1/10/18	1/10/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	20 pcs	1/10/18	1/10/18	0.00	0.04	Bandsaw1		
110	CNC Vertical Machining	20 pcs	1/11/18	1/11/18	0.00	23.89	HAAS1-1		
120	QC	20 pcs	1/11/18	1/11/18	0.00	0.00	QC2 Machining-1		
122	Mill Conv	20 pcs	1/12/18	1/12/18	0.00	17.38	Mill Conv 1		
124	QC	20 pcs	1/12/18	1/12/18	0.00	0.00	QC2 Machining-1		
130	QC	20 pcs	1/12/18	1/12/18	0.00	0.00	QC8 Machining-1		
140	Outsource	20 pcs	1/12/18	1/12/18	0.00	0.00	Outsource4		
150	Packaging	20 pcs	1/12/18	1/12/18	0.00	0.00	Packaging2		
160	QC	20 pcs	1/12/18	1/12/18	0.00	0.00	QC5		
180	Packaging	20 pcs	1/12/18	1/12/18	0.00	0.00	Packaging3-1		
190	QC21-SA	20 Ea	1/12/18	1/12/18	0.00	0.00	QC21		

Part Op 100 - Cut Blanks at 3.188"

Descriptions: 110 - 1-Machine per folio F341 DWG REV: FOLIO REV: 2- deburr and break all sharp edges

122 - Drill and c'bore as per dwg. Use DT10078.

140 - Issue P/O to ATG: 039046 1- Black Anodize as per Dwg 647.7800 2- PRIME AS PER DWG, SEE NOTE #2

Certification of Conformity is required

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

FEB 14 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6S1.750X2.250	20	39	0	0

Part Specifications

Specifications could not be found.

3x -> Fm138447 S035827
17x -> S030141 S035828

Plex 12/8/17 2:45 PM dart.poulin.mario



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PURCHASE ORDER PO039040

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	171201	647.3917	Doubler Issue P/O to ATG : HARD ANODIZE, COLOR BLACK, AND PRIME AS PER DWG 647.3900 REV. C	Firmed	2/21/18	8 pcs	0 pcs	8 pcs	\$8.01/pcs	\$64.08
						✓ 8x		AT 18/03/01		
6	171214	649.5213	Doubler ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG. (SEE NOTE 2)	Firmed	2/21/18	5 pcs	0 pcs	5 pcs	\$7.86/pcs	\$39.30
						6	6x	6	AT 18/03/01	
7	169390	647.7822	Eye Bolt Fitting RH Issue P/O to ATG : 1- Black Anodize as per Dwg 647.7800 Rev. A 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	Firmed	2/21/18	15 pcs	0 pcs	15 pcs	\$10.41/pcs	\$156.15
						✓ 15x		AT 18/03/01		
8	170589	RBE350A94- 3701-00	Main Rotor Rigging Tool -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A- 8625F TYPE 2 CLASS 2, Water sealant As per Dwg RBE350A94- 3701-00 Rev. 2A -Certificate of Conformity is required	Firmed	2/21/18	20 pcs	0 pcs	20 pcs	\$6.61/pcs	\$132.20
						20x		AT 18/02/13		
	171677			Firmed	2/21/18	2 pcs	20 pcs	2 pcs	\$6.61/pcs	\$13.22
				Sub Total:		22	0	22		\$145.42
9	170065	RBT18713-1	Body -Issue P/O to ATG PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant As Per Dwg RBT18713-1 Rev. 4 -Certificate of Conformity is required	Firmed	2/21/18	13 pcs	0 pcs	13 pcs	\$5.13/pcs	\$66.69
						✓ 13x		AT 18/02/13		
10	171523	RBWSI-HT- 12AS-1	Top -Issue P/O to ATG PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant	Firmed	2/21/18	10 pcs	0 pcs	10 pcs	\$5.13/pcs	\$51.30
						✓ 10x		AT 18/02/13		

DART AEROSPACE LTD		Work Order:	169390
Description: Eye Bolt Fitting, RH		Part Number:	647.7822
Inspection Dwg: 647.7800 Rev: NC2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC						
1.700	+/-0.005	1.700	✓		Uem HI-D8	
1.200	+/-0.005	1.200	✓			
R0.250	+/-0.005	R.250	✓		R-G	
2.600	+/-0.005	2.600	✓		Uem HI-D8	
R0.250	+/-0.005	R.250	✓		R-G	
R0.250	+/-0.005	R.250	✓		"	
0.135	+/-0.005	.138	✓		Uem HI-D8	
0.135	+/-0.005	.132	✓			
2.198	+/-0.005	2.198	✓			
72°	+/-0.5°					
45°	+/-0.5°					
0.285	+/-0.005	.285	✓			
0.331	+/-0.005	.331	✓			
R0.125	+/-0.005	R.125	✓		R-G	
Manual Milling						
Ø0.316	+0.006/-0.001	0.316	✓		Caliper	JCL-08
0.495	+/-0.005	0.495	✓			
Ø0.610	+/-0.005	0.610	✓			
0.131	+/-0.005	0.127	✓			
18°	+/-0.5°	18°	✓			
0.745	+/-0.005	0.746	✓			

Measured by: JCL	Audited by: DAS	Preliminary Approval:
Date: 18-02-05	Date: 18-02-13	Date:

Rev	Date	Change	Revised by	Approved
A	14.09.02	New Issue	KJ	

DART
AEROSPACE
S035905

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA

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www.dartaerospace.com



Eye Bolt Fitting RH

PART NO: 647.7822

Original Serial #: S035905

Revision:

Operation:

Change No:

Start up Operation 01/26/18

Job No: 169390



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914733

Date: 07-Mar-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
15 ea	Part: 647.7822 Rev: A Eye Bolt Fitting RH Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 22548 PO: PO039040 Line: 7		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>07/03/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			

A: _____ Date: _____

Closed: 2R Date: SEP 16 2020 **WORK ORDER NON-CONFORMANCE / UPDATE**Work Order update only ☐

Work Order: <u>169 390</u>	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. <u>647. 7822</u>	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No. <u>20-8460</u>	Scrap ☒	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	

e: 18-02-05 Step #: 122 QTY Effective: 15 MRR (QSI042) Approval **DAS 55 9-89** **AUG 06 2020**

Description Work Order Deviation	Disposition	
The reverse counter bore left marks on part by installing it.	Scrap	Completed By <u>J.C. - L. 18-02-05</u>
		Lead hand / Supervisor Approval Verification <u>20/06/26</u>
		QC / QA Coordinator Approval DAS 55 9-89 AUG 06 2020

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☒	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Technical Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☒	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Best Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER :					